Schill+Seilacher struktol®

Technical Data Sheet

STRUKTOL® MC-A

Mould cleaning compound

Composition

Curable rubber compound

Properties

Appearance		Light coloured rubber compound in a roll
Odour		Slightly aminic
Density	[kg/m^3]	1140
Physiological behaviour		Refer to safety data sheet
Storage stability		At least 12 months under normal storage conditions
Dimension		8 x 350 mm
Packaging		22 kg hobbocks

Properties

Cure temperature	[°C]	160 - 195
Cure time	[min]	5 - 30
Recommended cure		10 min at 175 °C

Recommendations for Application

STRUKTOL® MC-A is a curable rubber compound for in situ cleaning of moulds.

STRUKTOL® MC-A removes the deposits which build up during vulcanisation of rubber compounds. Deposits from silicone or fluoroelastomer compounds may not be removed with the same efficiency as for normal NR/SBR deposits.

STRUKTOL® MC-A is used for mould cleaning by placing the compound in the mould as for a normal cure cycle. The cleaning takes place during the cure.

Mould removal is not necessary. STRUKTOL® MC-A can be milled, extruded or otherwise processed with the usual manufacturing machines.

STRUKTOL® MC-A works by releasing active materials into the mould fouling. The penetrated deposit is combined with the cleaning compound. The cure temperatures should be between 160 °C and 195 °C with a minimum cure time of 5 minutes. Optimum curing temperature is 175 °C.

The effectiveness of cleaning depends on the kind of deposit, cure temperature and pressure. Higher temperatures accelerate the diffusion of the active materials into the dirt layer, but the corresponding reduction in cure time will prevent sufficient combination of the deposit onto the cleaning compound.

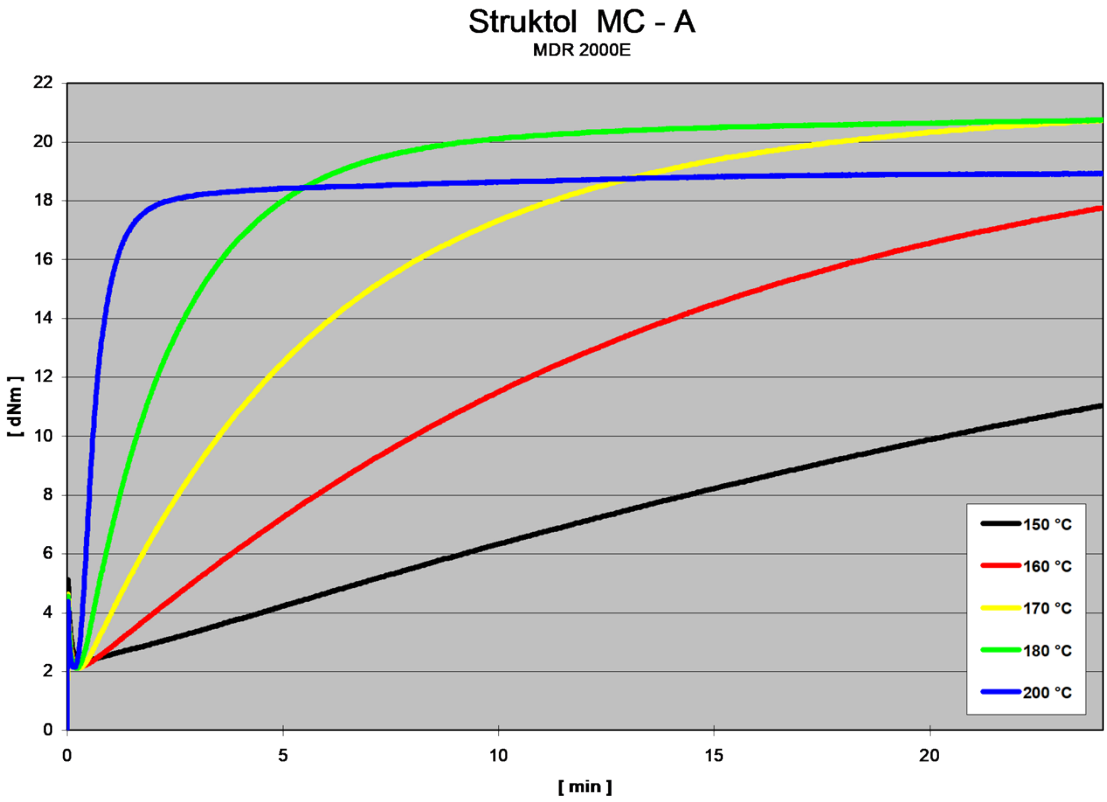
If using STRUKTOL® MC-A as a regular mould cleaning agent it is advisable to clean the mould more frequently to prevent the build up of difficult to remove deposits.

If starting with a very dirty mould it may be necessary to make more than one application of STRUKTOL® MC-A to completely remove the deposits. To obtain maximum cleaning effect it is essential that the mould be fully filled and adequate pressure is maintained throughout the cure.

With STRUKTOL® MC-A all commonly used steel alloys may be cleaned. We cannot recommend the use of STRUKTOL® MC-A for non-ferrous metals. If you are uncertain in applying our material please contact our technical agents for advice.

Influence of Cure Temperature and Time

The longer the curing time, the more efficient the cleaning effect. The following rheometer traces show the relationship between temperature and cure time. Optimum cure cycle is 10 minutes at 175 °C.



Cleaning of intricate moulds

For moulds with deep undercuts, to avoid hot tear problems it is necessary to use a cure cycle in which the vulcanisate is removed after reaching 80 % of optimum cure.

Cleaning of large moulds

For an economical use of STRUKTOL® MC-A, large moulds a filling compound can be used on which STRUKTOL® MC-A is applied as a veneer.

Minimising fuming problems

Areas where STRUKTOL® MC-A is in use must be adequately ventilated. It is advisable to have extraction equipment over presses. To reduce fuming in the atmosphere it is advisable to place the vulcanised STRUKTOL® MC-A in water immediately after stripping from the mould.

Another recommendation to reduce fuming is to use STRUKTOL® MC-A at the end of a day's moulding and remove the vulcanisate from the cold mould the next day.

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